

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005391**Date Inspected:** 05-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Xu Xian Ping  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 7-OBG Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 019 & 020 located on PCMK SP 631-001. Welders are identified as,054459. ZPMC QC is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 019,020,027 & 028 located on PCMK SP 551-001. Welders are identified as 054459 & 048810. ZPMC QC is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

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## WELDING INSPECTION REPORT

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For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 204-005 009,010,011,012 003389 6 A
2. SP 776-001 001 003888 10 AW
3. SP 633-001 025 003887 10 CE
4. SP 630-001 012 003886 10 AE
5. SP 548-001 015,016,017,018 003891 9 EE
6. SP 774-001 021,022,023,024 003892 9 EW
7. SP 590-001 011 003890 10 AE
8. BP 205-005 002 003893 6A

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress

For green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SSD1 DPSA3-9 8,9 004107 NA
2. SSD1 DPSA3-6 9 004106 NA

Sl # Section # Weld # Green Tag # Location

1. SSD1 DPSA3-7 9 NA NA
2. ESD1 DPSA3-15 9 NA NA
3. ESD1 DPSA3-11 9 NA NA
4. ESD1 DPSA3-14 9 NA NA

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract document

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for

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## WELDING INSPECTION REPORT

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your project.

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<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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